



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
  
Tel (613) 632-5200  
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D205-634-141  
Job Sheet 203970



Part No: D205-634-141      Job Qty: 1 pcs  
Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH  
  
Part Weight: 0 lbs      Status: New      Priority: Medium  
Job Created: 11/29/19      Job Tracking No:  
Due Date: 12/24/19      Created By: Marie Lajeunesse  
Type: Stock      Description:  
Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM  
Ship Via:

Bill of Materials

Job Routing

| Op No | Operation                  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier    |           | Sign-off |
|-------|----------------------------|-------|------------|----------|-----------|---------|------------------------|-----------|----------|
|       |                            |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier  | Lead Time |          |
| 110   | Skidtubes - 1              | 1 pcs | 12/24/19   |          | 0.00      | 2.00    | Skidtubes - 1          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 2          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 3          |           | MLA      |
|       |                            |       |            |          |           |         | Skidtubes - 4          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 5          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 6          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 7          |           |          |
| 120   | Skidtubes - Bend - 2 - B4B | 1 pcs | 12/24/19   |          | 0.50      | 1.00    | Skidtubes - Bend - B4B |           | MLA      |
| 130   | Skidtubes - 2 - B4B        | 1 pcs | 12/24/19   |          | 0.00      | 2.00    | Skidtubes - 1 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 2 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 3 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 4 - B4B    |           | TF       |
|       |                            |       |            |          |           |         | Skidtubes - 5 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 6 - B4B    |           |          |
| 140   | QC 5                       | 1 pcs | 12/24/19   |          | 0.00      | 0.00    | Skidtubes - 7 - B4B    |           |          |
|       |                            |       |            |          |           |         | QC 5 - 10              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 12              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 17              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 18              |           | BE       |
|       |                            |       |            |          |           |         | QC 5 - 19              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 22              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 24              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 3               |           |          |
|       |                            |       |            |          |           |         | QC 5 - 43              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 49              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 51              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 58              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 68              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 9               |           |          |
|       |                            |       |            |          |           |         | QC 5 - 50              |           |          |

59073



Container No: S236873  
  
Part: D205-634-141  
Job No: 203970  
Serial No/Batch: S236873  
Revision: H/I  
Inspector:  
Exp Date:  
Instructions: TC STC SH96-88 Issue 3, FAA STC SR00563

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CANADA  
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Email: sales@dartaero.com  
www.dartaerospace.com

|                                     |          |          |           |                          |                       |
|-------------------------------------|----------|----------|-----------|--------------------------|-----------------------|
| 150 Skidtubes - 3 - B4B             | 1<br>pcs | 12/24/19 | 0.00 2.00 | QC 5 - 30                |                       |
|                                     |          |          |           | QC 5 - 40                |                       |
|                                     |          |          |           | QC 5 - 61                |                       |
|                                     |          |          |           | QC 5 - 81                |                       |
|                                     |          |          |           | Skidtubes - 1 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 2 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 3 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 4 - B4B      | TF                    |
|                                     |          |          |           | Skidtubes - 5 - B4B      | BE                    |
|                                     |          |          |           | Skidtubes - 6 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 7 - B4B      |                       |
|                                     |          |          |           | QC 10 - 10               |                       |
|                                     |          |          |           | QC 10 - 18               |                       |
|                                     |          |          |           | QC 10 - 24               |                       |
|                                     |          |          |           | QC 10 - 43               |                       |
| 160 QC 10                           | 1<br>pcs | 12/24/19 | 0.00 0.00 | QC 10 - 50               |                       |
|                                     |          |          |           | QC 10 - 58               |                       |
|                                     |          |          |           | QC 10 - 9                |                       |
|                                     |          |          |           | QC 10 - 68               | DAS<br>DEC 12 2019 68 |
|                                     |          |          |           | QC 5 - 10                | 9-89                  |
|                                     |          |          |           | QC 5 - 12                |                       |
|                                     |          |          |           | QC 5 - 17                |                       |
|                                     |          |          |           | QC 5 - 18                |                       |
|                                     |          |          |           | QC 5 - 19                |                       |
|                                     |          |          |           | QC 5 - 22                |                       |
|                                     |          |          |           | QC 5 - 24                |                       |
|                                     |          |          |           | QC 5 - 3                 |                       |
|                                     |          |          |           | QC 5 - 43                |                       |
|                                     |          |          |           | QC 5 - 49                |                       |
|                                     |          |          |           | QC 5 - 51                |                       |
|                                     |          |          |           | QC 5 - 58                |                       |
|                                     |          |          |           | QC 5 - 68                | DAS<br>DEC 12 2019 68 |
|                                     |          |          |           | QC 5 - 9                 | 9-89                  |
|                                     |          |          |           | QC 5 - 50                |                       |
|                                     |          |          |           | QC 5 - 30                |                       |
|                                     |          |          |           | QC 5 - 40                |                       |
|                                     |          |          |           | QC 5 - 61                |                       |
|                                     |          |          |           | QC 5 - 81                |                       |
| 180 Handfinish - 2-1 Pressure- B4B  | 1<br>pcs | 12/24/19 | 0.00 0.50 | Handfinish - 2 - 1 - B4B |                       |
|                                     |          |          |           | Handfinish - 2 - 2 - B4B | DEC 12 2019           |
|                                     |          |          |           | Handfinish - 2 - 3 - B4B |                       |
|                                     |          |          |           | Handfinish - 2 - 4 - B4B |                       |
|                                     |          |          |           |                          |                       |
| 190 Powdercoat - 1 White Gl(A)- B4B | 1<br>pcs | 12/24/19 | 0.00 0.80 | Powdercoat - 1 - B4B     |                       |
|                                     |          |          |           | Powdercoat - 2 - B4B     |                       |
|                                     |          |          |           | Powdercoat - 3 - B4B     | BE 12-12-17           |
|                                     |          |          |           | Powdercoat - 4 - B4B     |                       |
|                                     |          |          |           |                          |                       |
| 200 QC 3                            | 1<br>pcs | 12/24/19 | 0.00 0.00 | QC 3 - 10                |                       |
|                                     |          |          |           | QC 3 - 13                |                       |
|                                     |          |          |           | QC 3 - 15                |                       |
|                                     |          |          |           | QC 3 - 17                |                       |
|                                     |          |          |           | QC 3 - 18                |                       |
|                                     |          |          |           | QC 3 - 2                 |                       |
|                                     |          |          |           | QC 3 - 28                |                       |
|                                     |          |          |           | QC 3 - 3                 |                       |
|                                     |          |          |           | QC 3 - 30                |                       |
|                                     |          |          |           | QC 3 - 34                |                       |

|                                        |          |          |           |  |                             |              |
|----------------------------------------|----------|----------|-----------|--|-----------------------------|--------------|
|                                        |          |          |           |  | QC 3 - 36                   |              |
|                                        |          |          |           |  | QC 3 - 41                   |              |
|                                        |          |          |           |  | QC 3 - 51                   |              |
|                                        |          |          |           |  | QC 3 - 58                   |              |
|                                        |          |          |           |  | QC 3 - 59                   | BFB 19-12-17 |
|                                        |          |          |           |  | QC 3 - 68                   |              |
|                                        |          |          |           |  | QC 3 - 9                    |              |
|                                        |          |          |           |  | QC 3 - 40                   |              |
|                                        |          |          |           |  | QC 3 - 19                   |              |
|                                        |          |          |           |  | QC 3 - 43                   |              |
|                                        |          |          |           |  | QC 3 - 24                   |              |
|                                        |          |          |           |  | QC 3 - 61                   |              |
|                                        |          |          |           |  | QC 3 - 81                   |              |
|                                        |          |          |           |  |                             |              |
| 210 Handfinish - 3-1- WingWalk-<br>B4B | 1<br>pcs | 12/24/19 | 0.00 1.33 |  | Handfinish - 3 - 1 -<br>B4B |              |
|                                        |          |          |           |  | Handfinish - 3 - 2 -<br>B4B | BFB 19-12-17 |
|                                        |          |          |           |  | Handfinish - 3 - 3 -<br>B4B |              |
|                                        |          |          |           |  | Handfinish - 3 - 4 -<br>B4B |              |
|                                        |          |          |           |  | Handfinish - 3 - 5 -<br>B4B |              |
| 220 QC 5                               | 1<br>pcs | 12/24/19 | 0.00 0.00 |  | QC 5 - 10                   |              |
|                                        |          |          |           |  | QC 5 - 12                   |              |
|                                        |          |          |           |  | QC 5 - 17                   |              |
|                                        |          |          |           |  | QC 5 - 18                   |              |
|                                        |          |          |           |  | QC 5 - 19                   |              |
|                                        |          |          |           |  | QC 5 - 22                   |              |
|                                        |          |          |           |  | QC 5 - 24                   |              |
|                                        |          |          |           |  | QC 5 - 3                    |              |
|                                        |          |          |           |  | QC 5 - 43                   |              |
|                                        |          |          |           |  | QC 5 - 49                   |              |
|                                        |          |          |           |  | QC 5 - 51                   |              |
|                                        |          |          |           |  | QC 5 - 58                   |              |
|                                        |          |          |           |  | QC 5 - 68                   | DEC 18 2019  |
|                                        |          |          |           |  | QC 5 - 9                    |              |
|                                        |          |          |           |  | QC 5 - 50                   |              |
|                                        |          |          |           |  | QC 5 - 30                   |              |
|                                        |          |          |           |  | QC 5 - 40                   |              |
|                                        |          |          |           |  | QC 5 - 61                   |              |
| 230 Packaging 3-1 - Stock - B4B        | 1<br>pcs | 12/24/19 | 0.00 0.00 |  | QC 5 - 81                   |              |
|                                        |          |          |           |  | Packaging 3 - 1 - B4B       | JRB          |
|                                        |          |          |           |  | Packaging 3 - 2 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 3 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 4 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 5 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 6 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 7 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 8 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 9 - B4B       |              |
|                                        |          |          |           |  | Packaging 3 - 10 -<br>B4B   |              |
|                                        |          |          |           |  | Packaging 3 - 11 -<br>B4B   |              |
|                                        |          |          |           |  | Packaging 3 - 12 -<br>B4B   |              |
|                                        |          |          |           |  | Packaging 3 - 13 -<br>B4B   |              |
|                                        |          |          |           |  | Packaging 3 - 14 -<br>B4B   |              |

DAS  
59  
9-89

DAS  
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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 16 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 17 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 18 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 19 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 20 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 21 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 22 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 23 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 24 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 25 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 26 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 27 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 28 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 29 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 30 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 31 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 32 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 33 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 34 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 35 - B4B |                    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | Packaging 3 - 36 - B4B |                    |
| 235 DC - 1 - B4B                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 1 pcs | 12/24/19 | 0.00 0.00 | DC - 1 - B4B           | BAS 21 DEC 19 2019 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | DC - 2 - B4B           | BAS 21 DEC 19 2019 |
| 240 QC 21 - FG                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 1 pcs | 12/24/19 | 0.00 0.00 | QC 21 - FG - 21        | BAS 21 DEC 19 2019 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | QC 21 - FG - 70        | BAS 21 DEC 19 2019 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |       |          |           | QC 21 - SA - 53        | BAS 21 DEC 19 2019 |
| Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)<br>120 - (CNC Delta 100 Bender)1-Bend as per program D2580.C on CNC Bender and Folio FT 16<br>130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.<br>140 - (QC5- Inspect part completeness to step on W/O)<br>150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 139019 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR<br>160 - QC10- Inspect visual per QSI004- ground welds)<br>170 - QC5- Inspect part completeness to step on W/O) Production .0000 * Attachments 180 HandFinish And realodine tube as per QSI 005 HandFinish2 (Pressure Wash p<br>180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)And realodine tube as per QSI 005<br>190 - (White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:30 AM 11:00 AM<br>200 - (QC3- Inspect Part Finish)<br>M 21/856. |       |          |           |                        |                    |

20/03

210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 52316952-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# 5229693  
220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024  
230 - 1 (Identify as per dwg & Stock Location: \_\_\_\_\_)Identify and pack for shipping as per PPPD205-634-141 Location : FG084  
235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004  
240 - (QC21- Final Inspection - Work Order Release)

Job BOM

| Part / Item   | Component Name          | Quantity       | Operation                          | Container            |
|---------------|-------------------------|----------------|------------------------------------|----------------------|
| D2580-1       | 205 Bent Tube           | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 5224585              |
| D2576-3       | Step (Machining Detail) | 1 pcs (1 ea)   | 150-Skidtubes - 3 - B4B            | 5177095              |
| D4202-1       | Spacer                  | 24 pcs (24 ea) | 150-Skidtubes - 3 - B4B            | 5197211              |
| AN3-5A        | Bolt                    | 2 Ea (2 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5216385              |
| AN4-45A       | Bolt                    | 8 Ea (8 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 4x5228006/4x5241397. |
| D2570         | Bushing                 | 16 pcs (16 ea) | 210-Handfinish - 3-1- WingWalk-B4B | 5221878-5222725      |
| D2594-1       | Plug                    | 8 pcs (8 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5229062              |
| D2594-3       | O-Ring                  | 8 pcs (8 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5045937.             |
| D2855         | Cap                     | 1 pcs (1 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5128188              |
| D4406-041     | Fwd Wearplate Assembly  | 1 pcs (1 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5238692              |
| D4406-043     | Aft Wearplate Assembly  | 1 pcs (1 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5239259.             |
| MS21042-4     | Nut                     | 8 Ea (8 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5158589              |
| NAS1149D0332J | Washer                  | 2 Ea (2 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5178378.             |

M U. 613529

Job Allocations

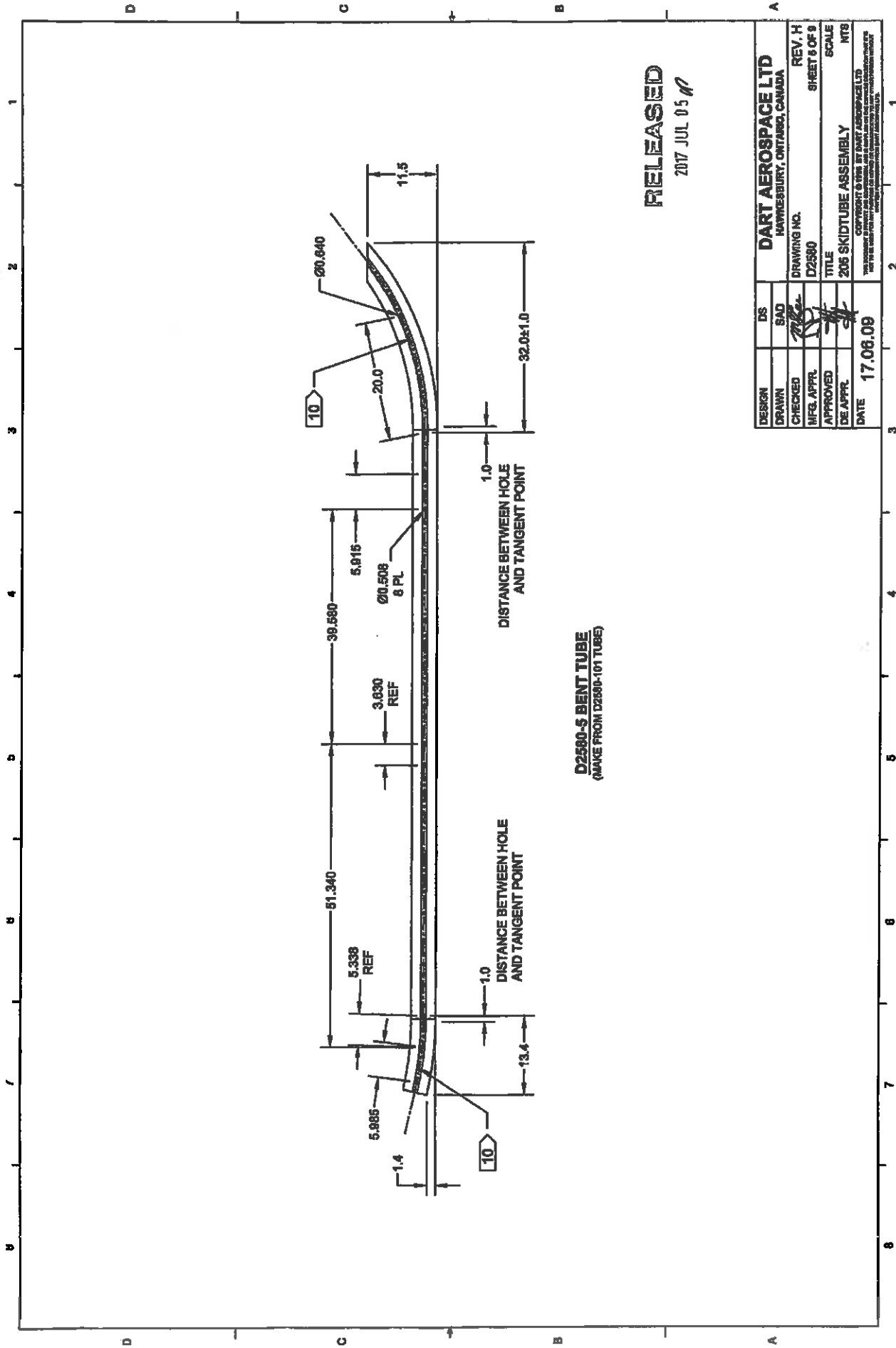
| Operation                          | Component Part | Required | Inventory | Allocated |
|------------------------------------|----------------|----------|-----------|-----------|
| 110-Skidtubes - 1                  | D2580-1        | 1        | 10        | 0         |
| 150-Skidtubes - 3 - B4B            | D2576-3        | 1        | 59        | 0         |
|                                    | D4202-1        | 24       | 1,222     | 0         |
| 210-Handfinish - 3-1- WingWalk-B4B | AN3-5A         | 2        | 199       | 0         |
|                                    | AN4-45A        | 8        | 29        | 0         |
|                                    | D2570          | 16       | 512       | 0         |
|                                    | D2594-1        | 8        | 188       | 0         |
|                                    | D2594-3        | 8        | 277       | 0         |
|                                    | D2855          | 1        | 67        | 0         |
|                                    | D4406-041      | 1        | 2         | 0         |
|                                    | D4406-043      | 1        | 2         | 0         |
|                                    | MS21042-4      | 8        | 68        | 0         |
|                                    | NAS1149D0332J  | 2        | 2,879     | 0         |

Part Specifications

Specifications could not be found.





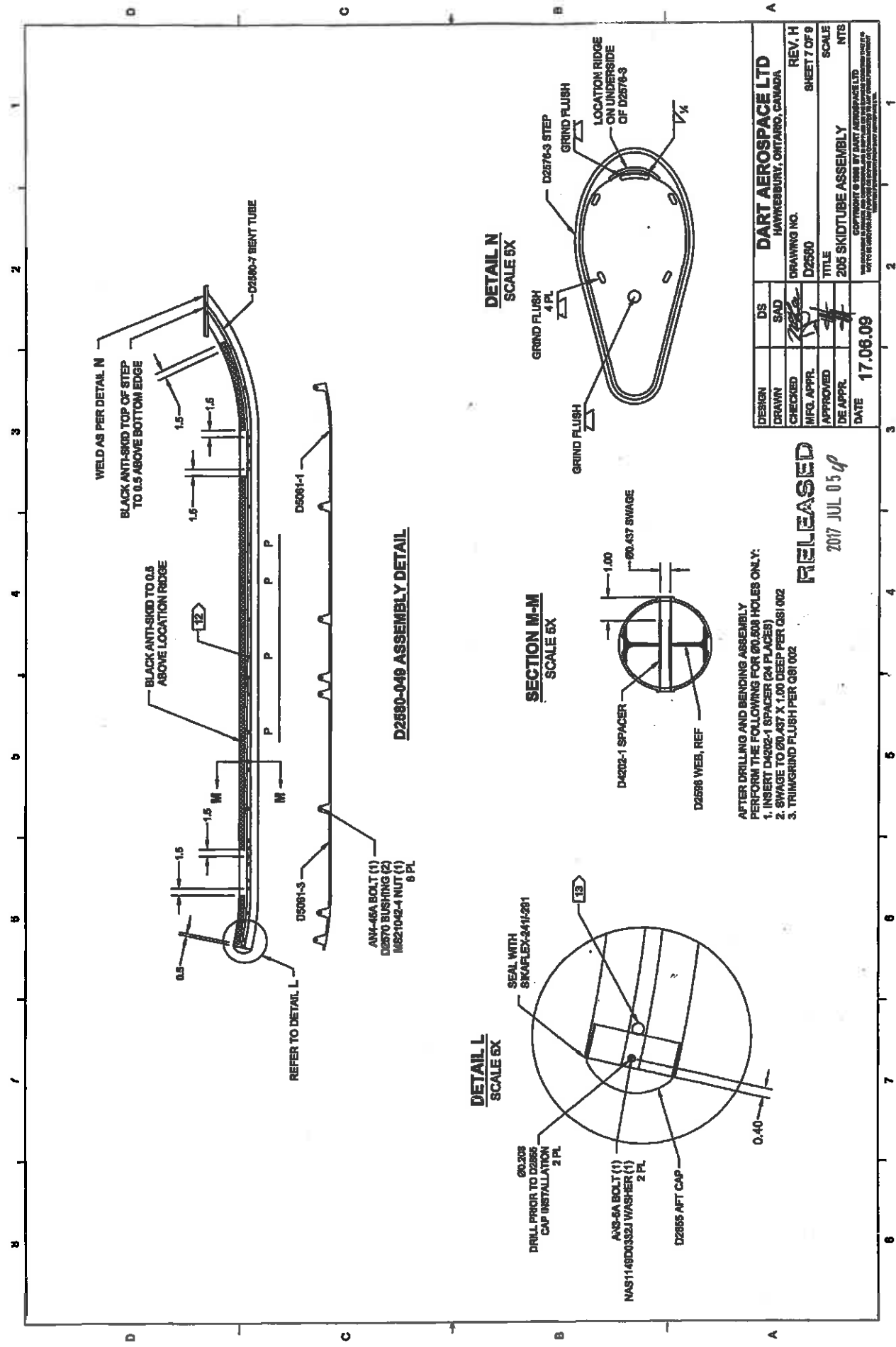


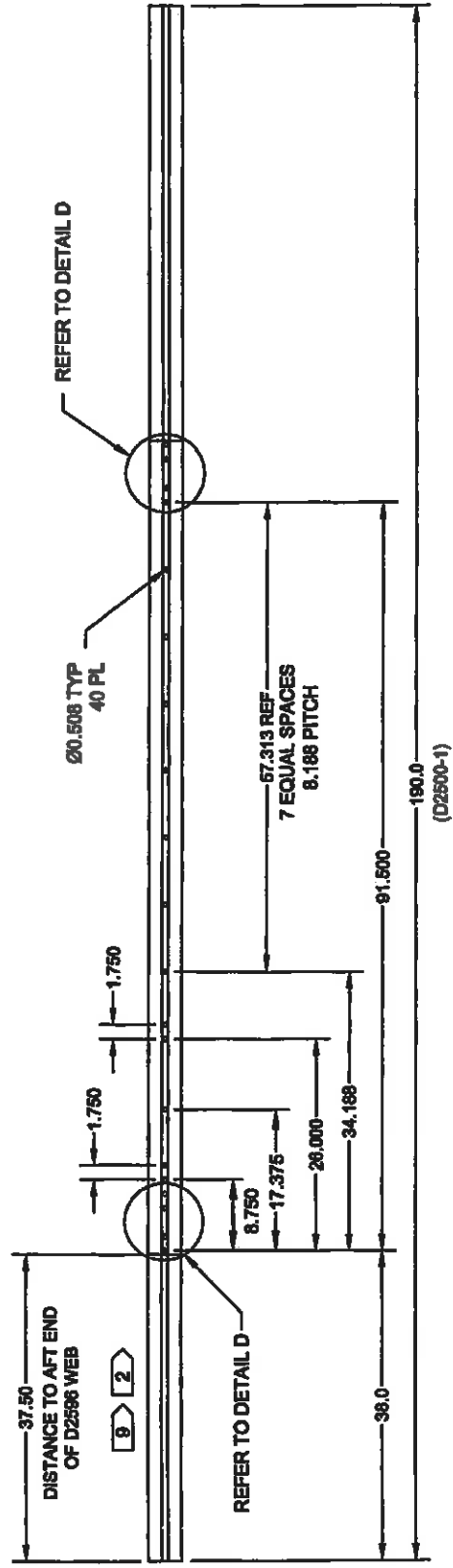
RELEASED  
2017 JUL 05

D2500-S BENT TUBE  
(MAKE FROM D2500-101 TUBE)

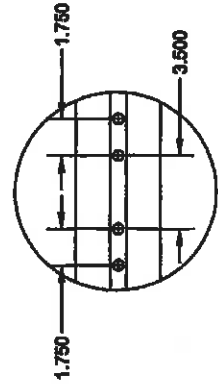
|             |          |                                                                                                                                                                                                                                                              |
|-------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| DESIGN      | DS       | DART AEROSPACE LTD<br>MAYNESBURY, ONTARIO, CANADA                                                                                                                                                                                                            |
| DRAWN       | SAD      |                                                                                                                                                                                                                                                              |
| CHECKED     |          | DRAWING NO. REV. H                                                                                                                                                                                                                                           |
| INFO. APPL. |          | D2500 SHEET 6 OF 9                                                                                                                                                                                                                                           |
| APPROVED    |          | TITLE SCALE                                                                                                                                                                                                                                                  |
| DE APPL.    |          | 205 SKIDTUBE ASSEMBLY NTS                                                                                                                                                                                                                                    |
| DATE        | 17.08.09 | COMPONENT & TUBE BY DART AEROSPACE LTD<br>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD<br>IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY<br>AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD |







# **D2590-101 TUBE**



**DETAIL D**  
SCALE 5X

**RELEASED**  
2017 JUL 05 11

|            |          |                             |
|------------|----------|-----------------------------|
| DESIGN     | DS       | DART AEROSPACE LTD          |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    | MS       | DRAWING NO. D2590           |
| INFO. APRR | MS       | REV. H SHEET 9 OF 9         |
| APPROVED   | MS       | TITLE 206 SKIDTUBE ASSEMBLY |
| DE APRR    | MS       | SCALE NT8                   |
| DATE       | 17.06.09 | DATE OF ISSUE 17.06.09      |



NCR No.

|                                                                                                                                                                                                                                                     |             |                              |  |                                                                                                                                                                                                      |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|
| Job: _____                                                                                                                                                                                                                                          |             | DISPOSITION                  |  | DEPARTMENT/PROCESS                                                                                                                                                                                   |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
| Part No. _____                                                                                                                                                                                                                                      |             | Rework<br>Scrap<br>Use-as-is |  | Skid-tube<br>Machining<br>Large Fab                                                                                                                                                                  |  | Cross tube<br>Small Fab<br>Finishing |  | Eng. (Non-AW)<br>Prod. Eng. Coord.<br>Rec/Store/Packaging                                                                                                                                                |  | Engineering<br>Water Jet<br>Supplier<br>Quality |  |                                                                                                                                                                                    |  |  |  |
| Date :                                                                                                                                                                                                                                              | Sequence #: | QTY Affected :               |  | MRB (QSI042)                                                                                                                                                                                         |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                    |             |                              |  | Disposition                                                                                                                                                                                          |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
| <div>Root Cause</div> <div><div>Operator</div><div>Manufacturing Process</div><div>Equip/Tooling</div><div>Handling/Preservation</div><div>Material</div><div>Product Improvement</div><div>Process Improvement</div><div>Human Factors</div></div> |             |                              |  | FAULT CATEGORY                                                                                                                                                                                       |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
|                                                                                                                                                                                                                                                     |             |                              |  | <div>Pressure/Forced</div> <div>Bending</div> <div>Crushing</div> <div>Cracks</div> <div>Crimp/Kink/Ripple/Wave/Twist</div> <div>Marks/Chatter</div> <div>Mislabeled</div> <div>Other/Details:</div> |  |                                      |  | <div>Contamination</div> <div>Misaligned/off center</div> <div>BOM/Route</div> <div>Broken/Damage/Defect</div> <div>Incomplete/Unclear Instructions</div> <div>Drill Holes</div> <div>Fit/Function</div> |  |                                                 |  | <div>Power Loss/Surge</div> <div>Folio/Program</div> <div>Grain Direction</div> <div>Weld</div> <div>Wrong Stock Pulled</div> <div>Out of Sequence</div> <div>Off-set/Set-up</div> |  |  |  |
|                                                                                                                                                                                                                                                     |             |                              |  | <div>Positioned Wrong</div> <div>Outside Tolerance</div> <div>Drawing</div> <div>Finish</div> <div>Part Lost/Missing</div> <div>Misread</div>                                                        |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
|                                                                                                                                                                                                                                                     |             |                              |  |                                                                                                                                                                                                      |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
|                                                                                                                                                                                                                                                     |             |                              |  | Completed By                                                                                                                                                                                         |  |                                      |  | Lead hand / Supervisor                                                                                                                                                                                   |  |                                                 |  |                                                                                                                                                                                    |  |  |  |
|                                                                                                                                                                                                                                                     |             |                              |  | QC / QA Coordinator                                                                                                                                                                                  |  |                                      |  |                                                                                                                                                                                                          |  |                                                 |  |                                                                                                                                                                                    |  |  |  |